

Work Order ID 70781

Wednesday, June 15, 2011 9:11:49 AM



Page 1

Item ID: D3793-1

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 6/15/2011 Start Qty: 16.00

Required Date: 6/22/2011 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 6/15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3793	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B11-6-23

18

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/6/12/24

18

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Page 2

Item ID: D3793-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 6/15/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

SB 11/06/29

18

Brake NC

1-Deburr if necessary ☐ 2-Form on Brake as per Dwg D3793 using Jigs ☐ 3-Form
Joggle on brake using Jig as per Dwg D3793

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 11/06/29

18

Quality Control

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

☐ OVEN TEMPERATURE:

☐ FINISH TIME:

9:10

3200F

9:40

18x 11/07/06

M 11/5/28

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Page 3

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				18	0	BR 11-7-6	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-18</u> Memo	0.00 0.00				18	0	BR 11-7-6	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>MF</u> 11-07-06	

Picklist Print

Wednesday, June 15, 2011 9:11:56 AM

Page 1

Work Order ID: 70781



Parent Item: D3793-1



Parent Item Name: Wearshoe



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	236.6630	0.5902	9.940211	14		
											1311-6-23		

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

236.663

116623

0.2

117550

9.363

117933

227.1

117933

18

DART AEROSPACE LTD		Work Order: 70781
Description: Wearshoe		Part Number: D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.191	✓		V RB02	
0.300 x 0.300	+/-0.010	3.4 x 3.06	✓		V	
1.885	+/-0.010	1.889	✓		V	
2.000	+/-0.010	2.000	✓		V	
5.00	+/-0.030	5.00	✓		V RB02	
8.00	+/-0.030	8.00	✓		T RB01	
14.00	+/-0.030	14.06	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.066	+/-0.010	14.066	✓		T	
18.983	+/-0.010	18.983	✓		T	
23.900	+/-0.010	23.900	✓		T	
27.400	+/-0.010	27.400	✓		T	
29.400	+/-0.010	29.400	✓		T	
32.900	+/-0.010	32.900	✓		T	
0.040	+/-0.010	0.034	✓		V	

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 4-6-23	Date: 14/06/24	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

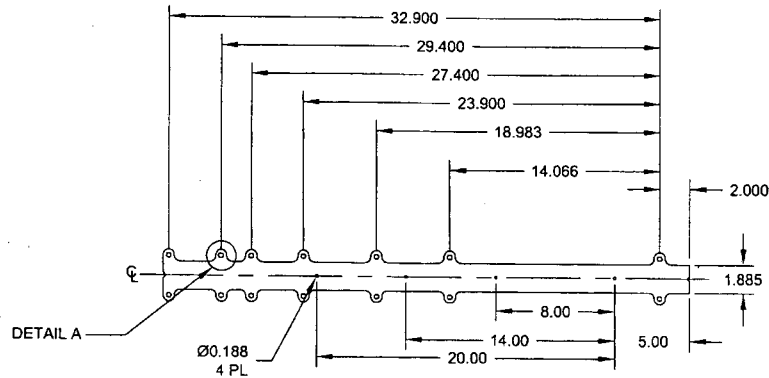
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

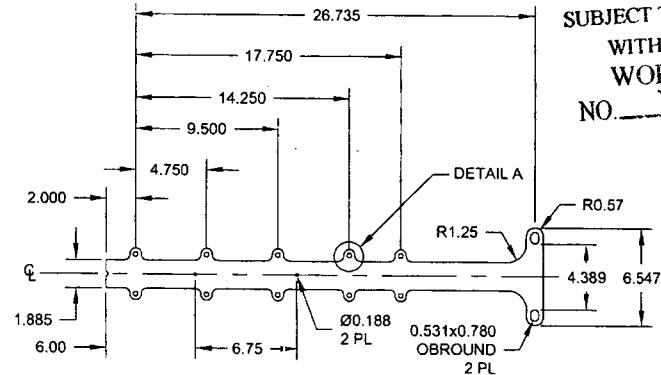
8 7 6 5 4 3 2 1

RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70781

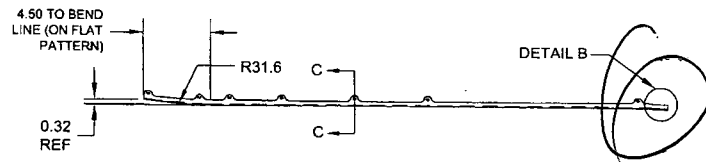
PH-06-15



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDOMEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

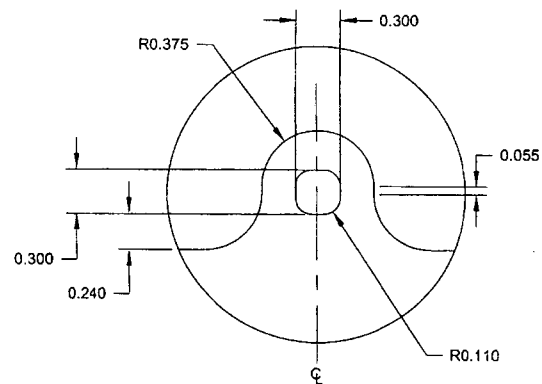
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

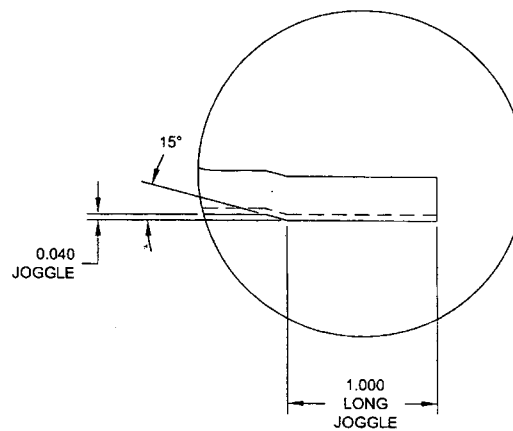
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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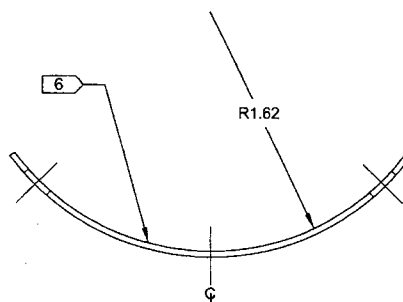
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

20781

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1

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